

Work Order ID 91648

October-18-12 9:55:25 AM

91648

Page 1

Item ID: D407-581-111

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Pre-Flight Installation

Start Date: 10/11/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/02/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date: 10-18 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

NR1

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D206-581

C

100

100

DC

Document Control

DOCUMENT CONTROL

No Stamps Label

0.00

*DAS
15
29
10-18*

110

110

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

*DAS
15
29
10-18*

10-18-12

SA

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

Date: _____

QA Closed: Date:

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS										
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>									
Part No. _____																
NCR No. _____																
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector							
Doc/Data																
Equip/Tooling																
Operator																
Material																
Setup																
Other																
Process																
Supplier																
Training																
Unapproved																
FAULT CATEGORY																
Landing Gear				General												
Bending	<input type="checkbox"/>			Bend	<input type="checkbox"/>			Grain	<input type="checkbox"/>			Ovalized	<input type="checkbox"/>			Pressure/Forced
Centre Not Concentric to O/S	<input type="checkbox"/>			BOM/Route	<input type="checkbox"/>			Hardware	<input type="checkbox"/>			Over/Under tolerance	<input type="checkbox"/>			Temperature/Cure
Cracks	<input type="checkbox"/>			Broken/Damaged	<input type="checkbox"/>			Inspection Incomplete	<input type="checkbox"/>			Part Incorrect	<input type="checkbox"/>			Weld
Crushed/Crimped.	<input type="checkbox"/>			Burrs	<input type="checkbox"/>			Instructions Incomplete/Unclear	<input type="checkbox"/>			Part Lost/Missing	<input type="checkbox"/>			Wrong Stock Pulled
Cuffs	<input type="checkbox"/>			Contamination	<input type="checkbox"/>			Maintenance	<input type="checkbox"/>			Part Moved	<input type="checkbox"/>			
Heat Treat	<input type="checkbox"/>			Countersink	<input type="checkbox"/>			Mislabeled	<input type="checkbox"/>			Positioned Wrong	<input type="checkbox"/>			
Inspection Strip in Tube	<input type="checkbox"/>			Cut Too Short	<input type="checkbox"/>			Misread	<input type="checkbox"/>			Power Loss/Surge	<input type="checkbox"/>			
Ripples in Bend	<input type="checkbox"/>			Drill Holes	<input type="checkbox"/>			Offset	<input type="checkbox"/>			Other	<input type="checkbox"/>			
Torque Waves in Extrusion	<input type="checkbox"/>			Drawing	<input type="checkbox"/>			Out of Calibration	<input type="checkbox"/>				<input type="checkbox"/>			
Turning Sequence	<input type="checkbox"/>			Finish	<input type="checkbox"/>			Out of Sequence	<input type="checkbox"/>				<input type="checkbox"/>			
Wave/Twist in Tube	<input type="checkbox"/>			Folio	<input type="checkbox"/>			Outside Dimensions	<input type="checkbox"/>				<input type="checkbox"/>			

Work Order ID 91648

91648

Page 2

October-18-12 9:55:25 AM

Item ID: D407-581-111

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Pre-Flight Installation

Stop

NS2

Start Date: 10/11/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/02/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Packaging

Packaging

0.00

0.00

11

10/11/154

Packaging

Memo

Identify and pack for shipping as per PPP D407-581-111
Location: 31
PPP Rev:

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Canceled

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS										
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>									
Part No. _____																
NCR No. _____																
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector							
Doc/Data																
Equip/Tooling																
Operator																
Material																
Setup																
Other																
Process																
Supplier																
Training																
Unapproved																
FAULT CATEGORY																
Landing Gear				General												
Bending	<input type="checkbox"/>			Bend	<input type="checkbox"/>			Grain	<input type="checkbox"/>			Ovalized	<input type="checkbox"/>			Pressure/Forced
Centre Not Concentric to O/S	<input type="checkbox"/>			BOM/Route	<input type="checkbox"/>			Hardware	<input type="checkbox"/>			Over/Under tolerance	<input type="checkbox"/>			Temperature/Cure
Cracks	<input type="checkbox"/>			Broken/Damaged	<input type="checkbox"/>			Inspection Incomplete	<input type="checkbox"/>			Part Incorrect	<input type="checkbox"/>			Weld
Crushed/Crimped.	<input type="checkbox"/>			Burrs	<input type="checkbox"/>			Instructions Incomplete/Unclear	<input type="checkbox"/>			Part Lost/Missing	<input type="checkbox"/>			Wrong Stock Pulled
Cuffs	<input type="checkbox"/>			Contamination	<input type="checkbox"/>			Maintenance	<input type="checkbox"/>			Part Moved	<input type="checkbox"/>			
Heat Treat	<input type="checkbox"/>			Countersink	<input type="checkbox"/>			Mislabeled	<input type="checkbox"/>			Positioned Wrong	<input type="checkbox"/>			
Inspection Strip in Tube	<input type="checkbox"/>			Cut Too Short	<input type="checkbox"/>			Misread	<input type="checkbox"/>			Power Loss/Surge	<input type="checkbox"/>			
Ripples in Bend	<input type="checkbox"/>			Drill Holes	<input type="checkbox"/>			Offset	<input type="checkbox"/>			<input type="checkbox"/>	<input type="checkbox"/>			Other
Torque Waves in Extrusion	<input type="checkbox"/>			Drawing	<input type="checkbox"/>			Out of Calibration	<input type="checkbox"/>				<input type="checkbox"/>			
Turning Sequence	<input type="checkbox"/>			Finish	<input type="checkbox"/>			Out of Sequence	<input type="checkbox"/>				<input type="checkbox"/>			
Wave/Twist in Tube	<input type="checkbox"/>			Folio	<input type="checkbox"/>			Outside Dimensions	<input type="checkbox"/>				<input type="checkbox"/>			

Picklist Print

October-18-12 9:55:25 AM

Page 1

Work Order ID: 91648

Parent Item: D407-581-111

Parent Item Name: Pre-Flight Installation

Start Date: 10/11/12

Required Date: 11/02/12

Start Qty: 1.00

Required Qty: 1.00

Comments: Ipp Rev:A New Issue 10-07-16 JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bln Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D407-581-011 Pre-Flight Step Installation, LH/RH		Manufactured	No			100	Each	2.0000	2	2	SJ		
D206-581-015 Step Handle Installation		Manufactured	No	Location FG031	Location 88545	Loc Qty 2	Loc Qty 100	Loc Code Each	Loc Code 4.0000	2	4	12/10/2012	SL
				Location FG031	Location 82908 87404	Loc Qty 4	Loc Qty 2	Loc Code	Loc Code	2	0		

Used
in D206-581-113

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other						

SMB

5.0 PART LIST

5.1 D407-581-111/-011 AND D206-581-113/-013/-014/-015/-017 KITS

Qty -111	Qty -113	Qty -011	Qty -013	Qty -014	Qty -015	Qty -017	Part Number	Description
X							D407-581-111	PRE-FLIGHT KIT (407)
	X						D206-581-113	PRE-FLIGHT KIT (206A/B/L/L1/L3/L4)
-2-	-X-						D407-581-011	PRE-FLIGHT STEP KIT, LH/RH (407)
1		X					D206-581-013	PRE-FLIGHT STEP KIT, LH (206A/B/L/L1/L3/L4)
1			X				D206-581-014	PRE-FLIGHT STEP KIT, RH (206A/B/L/L1/L3/L4)
-4-	-4-			X			D206-581-015	STEP HANDLE KIT
					X		D206-581-017	RETENTION STRAP KIT
					2		D3031-3	LOOP
	1	1	1				D4101-041	PRE-FLIGHT STEP ASSEMBLY
		1					D4102-1	SHIM (206 LH)
			1				D4102-2	SHIM (206 RH)
	1						D4102-3	SHIM (407)
				1			D4103-1	STEP HANDLE
					1		D4104-041	DOUBLER ASSEMBLY
						1	D4105-1	STRAP
					2		80-004-2D8	INSERT
					2		80-005-3-8	INSERT
6	6	6			8		80-005-3-16	INSERT
					2		CR3243-4-1	RIVET
					2		MS21042L3	NUT
					2		MS24694-S47	SCREW
					2		MS24694-S50	SCREW
					2		MS24694-S52	SCREW
					2		MS27039-4-11	SCREW
6	6	6				2	MS27039-4-14	SCREW
						2	NAS1149D0332J	WASHER (or AN960JD10L)
6	6	6	2				NAS1149D0416J	WASHER (or AN960JD416L)
			2				NAS1149D0463J	WASHER (or AN960JD416)

SMB

5.0 PART LIST

5.1 D407-581-111/-011 AND D206-581-113/-013/-014/-015/-017 KITS

Qty -111	Qty -113	Qty -011	Qty -013	Qty -014	Qty -015	Qty -017	Part Number	Description
X							D407-581-111	PRE-FLIGHT KIT (407)
	X						D206-581-113	PRE-FLIGHT KIT (206A/B/L/L1/L3/L4)
2		X					D407-581-011	PRE-FLIGHT STEP KIT, LH/RH (407)
	1		X				D206-581-013	PRE-FLIGHT STEP KIT, LH (206A/B/L/L1/L3/L4)
	1			X			D206-581-014	PRE-FLIGHT STEP KIT, RH (206A/B/L/L1/L3/L4)
4	4			X			D206-581-015	STEP HANDLE KIT
					X		D206-581-017	RETENTION STRAP KIT
					2		D3031-3	LOOP
	1	1	1				D4101-041	PRE-FLIGHT STEP ASSEMBLY
		1					D4102-1	SHIM (206 LH)
			1				D4102-2	SHIM (206 RH)
	1						D4102-3	SHIM (407)
			1				D4103-1	STEP HANDLE
				1			D4104-041	DOUBLER ASSEMBLY
					1		D4105-1	STRAP
					2		80-004-2D8	INSERT
					2		80-005-3-8	INSERT
	6	6	6		8		80-005-3-16	INSERT
					2		CR3243-4-1	RIVET
					2		MS21042L3	NUT
					2		MS24694-S47	SCREW
					2		MS24694-S50	SCREW
					2		MS24694-S52	SCREW
					2		MS27039-4-11	SCREW
	6	6	6				MS27039-4-14	SCREW
				2			NAS1149D0332J	WASHER (or AN960JD10L)
	6	6	6	2			NAS1149D0416J	WASHER (or AN960JD416L)
				2			NAS1149D0463J	WASHER (or AN960JD416)

Work Order ID 91648

October-18-12 9:55:25 AM

Item ID: D407-581-111

Accept

91648***N900040100***Setup Start ***NS1***Stop ***NS2***

Revision ID:

Item Name: Pre-Flight Installation

Start Date: 10/11/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/02/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

PL

QC:

Date: *10-18* Tooling:

Date:

Date: SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Draw Nbr	Revision Nbr
D206-581	C

100 DOCUMENT CONTROL

100

DC

Document Control

No sta Label

0.00

MLJ 12-10-26

0.00

Memo Photocopy bluefile & type labels per PPPD407-581-111 CHG001

110 Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
		Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
		Use-as-is <input type="checkbox"/>	Work Order Update <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
				Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
				Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									
FAULT CATEGORY									
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions					
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other					
				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled					